

# Work Order ID 53121

October 22, 2009 3:08:20 PM



Page 1

Item ID: D412-761-047

Accept



Setup Start



Revision ID: D

Item Name: Door Mounted Instrument Panel

Stop



Start Date: 10/23/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 10/30/2009 Req'd Qty: 1.00

Customer:

Reference:

Approvals: Process Plan: mf Date: 09-10-22 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
IIN D412-761	Rev D

100 DOCUMENT CONTROL 0.00



DC

Memo

0.00

Document Control

Photocopy bluefile & type labels per PPP D412-761-047 CHG001

Sorholz

for BG 09/10/23

110 Pick Kit 0.00



Packaging

Memo

0.00

Packaging

9/10/26 RSD

120 QC4- 100% Inspect kits for completeness 0.00



QC

Memo

0.00

Quality Control

2) Sorholz

ⓧ ⓧ

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 53121**

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Item ID: D412-761-047

Accept



Setup Start



Revision ID: D

Stop



Item Name: Door Mounted Instrument Panel

Start Date: 10/23/2009 Start Qty: 4.00



Cust Item ID:

Required Date: 10/30/2009 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 	Packaging	0.00							
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D412-761-047								
	Location:								
	PPP Rev: <u>Draft</u>								
140 	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

9/10/28

09/10/29

PR 09-10-28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

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Work Order ID: 53121

Parent Item: D412-761-047RevD

Parent Item Name: Door Mounted Instrument Panel

Comments:

Start Date: 10/23/2009

Required Date: 10/30/2009

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3705-041RevC Instrument Panel Assembly	71	Manufactured	No			110	Each	4.0000	4.0000			

Warehouse  
Location

Main Warehouse

ST

46021

Loc Qty

4

4

Loc Code

110

Each

16.0000

8.0000

46021 SEP

D3707-1RevB  
MOUNTING LUG



Warehouse  
Location

Main Warehouse

ST

44726

46022

Loc Qty

16

4

12

Loc Code

110

Each

5.0000

4.0000

44726 SEP

D3790-1RevB  
INDEXING BLOCK



Warehouse  
Location

Main Warehouse

ST

44948

46756

Loc Qty

5

1

4

Loc Code

44948 9/10/26 @56

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Work Order ID: 53121

Parent Item: D412-761-047RevD

Parent Item Name: Door Mounted Instrument Panel

Start Date: 10/23/2009

Required Date: 10/30/2009

Comments:

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3867-1RevPRELIM Connector Plate		Manufactured	No			110	Each	9.0000	4.0000			

Warehouse  
Location

Loc Qty

Loc Code

Main Warehouse

ST

9

44594

5

46024

4

44594 SF

AN3-3A

Purchased

No

110

Each

161.0000

16.0000

Bolt

Warehouse  
Location

Loc Qty

Loc Code

Main Warehouse

ST

161

111925

11

112314

50

112720

100

111925 SF

AN526C1032R6

Purchased

No

110

Each

852.0000

24.0000

Screw

Warehouse  
Location

Loc Qty

Loc Code

Main Warehouse

ST

852

1892

852

1892 9/10/26 90 SF

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Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



# Picklist Print

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Work Order ID: 53121

Parent Item: D412-761-047RevD

Parent Item Name: Door Mounted Instrument Panel


Start Date: 10/23/2009

Required Date: 10/30/2009

Comments:

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN743-12 <i>X2</i>  Clip		Purchased	No			110	Each	51.0000	8.0000			

Warehouse                      Loc Qty                      Loc Code  
Location

Main Warehouse

ST

51

100798

50

11492


1

110

Each

5,955.000

24.0000

AN960JD10L *X6*  
  
Washer

Warehouse                      Loc Qty                      Loc Code  
Location

Main Warehouse

ST

5955

101291

16

104885

153

105793

236

109632

550

110985

5000

9/10/26 *sf*  
(14)

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Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Work Order ID: 53121

Parent Item: D412-761-047RevD

Parent Item Name: Door Mounted Instrument Panel

Start Date: 10/23/2009

Required Date: 10/30/2009

Comments:

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS21075L3 <i>x6</i>		Purchased	No			110	Each	2.0000	24.0000			

Nutplate

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	2	
112690	2	

MS24693-C272 *x4*

Purchased

No

110

Each

1,448.000

16.0000

Screw

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	1448	
17137	519	
17831	520	
8814	3	
8815	46	
9063	60	
9370	300	

*M112991 SP*

*8875 9/10/20 SP*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

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Work Order ID: 53121

Parent Item: D412-761-047RevD

Parent Item Name: Door Mounted Instrument Panel


Start Date: 10/23/2009

Required Date: 10/30/2009

Comments:

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS27039-1-17 ✓  Screw		Purchased	No			110	Each	98.0000	4.0000			

Warehouse                      Loc Qty                      Loc Code  
Location

Main Warehouse

ST    98

11540    98

MT11540 sf

MS27039-1-27 ✓  Screw		Purchased	No			110	Each	100.0000	4.0000			
---	--	-----------	----	--	--	-----	------	----------	--------	--	--	--

Warehouse                      Loc Qty                      Loc Code  
Location

Main Warehouse

ST    100

110606    100

MT110606 sf

MS21042L3 ✓  Nut		Purchased	No			110	Each	3,430.000	16.0000			
--	--	-----------	----	--	--	-----	------	-----------	---------	--	--	--

Warehouse                      Loc Qty                      Loc Code  
Location

Main Warehouse

ST    3430

110844    32

111274    35

111668    863

112314    2000

112385    500

M 111668 9/10/26 70 sf

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

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Work Order ID: 53121



Parent Item: D412-761-047RevD



Parent Item Name: Door Mounted Instrument Panel

Start Date: 10/23/2009

Required Date: 10/30/2009

Comments:

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS21919-WDG8 <i>X2</i>		Purchased	No			110	Each	93.0000	8.0000			
<i>S</i>												
Clamp												

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

93

100202

84

4535

9

4535

9/10/26

*RSF*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



## 5.0 PARTS LIST, FULL VERTICAL REFERENCE DOOR MOD

QTY -041	QTY -043	QTY -045	QTY -047	QTY -049	PART NUMBER	DESCRIPTION
X					D412-761-041	FULL VERTICAL REFERENCE DOOR KIT, LH
	X	1			D412-761-043	MODIFIED LATCH MECHANISM KIT, LH
1		X			D412-761-045	LARGE BUBBLE WINDOW KIT, LH
1			X		D412-761-047	DOOR MOUNTED INSTRUMENT PANEL KIT, LH
1				X	D412-761-049	ARMREST KIT, LH
	1				D3589-041	LATCH ASSEMBLY
	1				D3589-047	FORWARD GUIDE
	1				D3589-049	AFT GUIDE
	2				MS16997-22	SCREW
	2				AN960JD6L	WASHER
	2				MS21042L06	NUT
		1			D3676-1	LARGE BUBBLE WINDOW
		1			D3678-1	PLACARD
		1			D3678-3	PLACARD
		1			D3700-1	INBOARD WINDOW DOUBLER
		1			D3700-3	OUTBOARD WINDOW DOUBLER
		1			D3701-1	FLOOR DOUBLER
		1			D3702-1	FORWARD DOUBLER
		1			D3703-1	AFT DOUBLER
		1			D3703-3	AFT CORNER DOUBLER
		1			D3703-5	AFT CAP
		1			D3704-1	ESCUTCHEON
		1			D3704-3	ESCUTCHEON
		1			D3708-1	ANGLE
		1			D3708-3	ANGLE
		1			D3709-1	ANGLE
		1			D3709-3	ANGLE
		1			D3802-1-135	SEAL
		1			DT9458	CUTTING TEMPLATE
		26			AN3-7A	BOLT
		52			AN960JD10	WASHER
		26			MS21042L3	NUT
		1			MS24694-C5	SCREW (OR MS24694-S5)
		1			MS24694-C13	SCREW (OR MS24694-S13)
			1		D3705-041	INSTRUMENT PANEL ASSEMBLY
			1		D3705-043	* INSTRUMENT PANEL WELDMENT
			1		D3335-1	* SPRING
			1		D3705-5	* ACCESS PANEL
			1		D3706-5	* PIN
			2		D3707-3	* MOUNTING LUG
			4		AN526C1032R6	* SCREW
			1		AN960JD516	* WASHER
			1		MS171498	* SPRING SLOTTED PIN
			4		MS24693-C272	* SCREW (OR MS24693-S272)

\*DENOTES PART IS INCLUDED WITH ASSEMBLY ABOVE

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Revision: D

Date: 09.06.18

53121

(CONTINUED FROM PAGE 8)

QTY -041	QTY -043	QTY -045	QTY -047	QTY -049	PART NUMBER	DESCRIPTION
			(2)		D3707-1	MOUNTING LUG
			(1)		D3790-1	INDEXING BLOCK
			(1)		D3867-1	CONNECTOR PLATE
			(4)		AN3-3A	BOLT
			(6)		AN526C1032R6	SCREW
			(2)		AN743-12	BRACKET
			(6)		AN960JD10L	WASHER
			(6)		MS21075L3	NUTPLATE (OR MS21073-3)
			(4)		MS24693-C272	SCREW (OR MS24693-S272)
			(1)		MS27039-1-17	SCREW
			(1)		MS27039-1-27	SCREW
			(4)		MS21042L3	NUT
			(2)		MS21919WDG8	CLAMP
				1	D3694-041	MOUNTING PLATE ASSEMBLY
				1	D3694-1	* KEYWAY
				1	D3694-3	* PROTECTIVE PLATE
				1	D3694-5	* MOUNTING PLATE
				1	AN526C1032R8	* SCREW
				5	AN960JD10	* WASHER
				4	MS21042L3	* NUT
				2	MS21209F1-20	* HELI-COIL, SCREW LOCKING (RED)
				1	MS24693-C271	* SCREW (OR MS24693-S271)
				4	MS24693-C273	* SCREW (OR MS24693-S273)
				1	D3695-041	SLIDER ASSEMBLY
				1	D3695-1	* SLIDER
				1	D3695-3	* STOPPER
				1	D3801-1	* HAND RETRACTABLE SPRING PLUNGER
				1	MS21209F6-25	* HELI-COIL, SCREW LOCKING (RED)
				4	MS21209F1-20	* HELI-COIL, SCREW LOCKING (RED)
				4	MS24693-C276	* SCREW (OR MS24693-S276)
				1	D3780-041	ARMREST ASSEMBLY
				1	D3696-041	* ARM ASSEMBLY
				1	D3696-1	** ARM
				1	D3801-3	** HAND RETRACTABLE SPRING PLUNGER
				1	D3781-041	* LATERAL CUSHION ASSEMBLY
				1	D3781-043	* ARMREST CUSHION ASSEMBLY
				1	D3785-3	* BRACKET
				1	D3977-1	* BOLT
				1	D3978-1	* NUT (CASTELLATED)
				1	D3979-1	* WASHER (SQUARE HOLE)
				2	AN970-6	* WASHER
				1	MS24665-302	* COTTER PIN
				2	MS21042L3	* NUT
				2	MS24693-C272	* SCREW
				2	MS24693-C277	* SCREW
				1	NAS1149D0663J	* WASHER

\* DENOTES PART IS INCLUDED WITH ASSEMBLY ABOVE

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Revision: D

Date: 09.06.18

5/12/11